

Work Order ID 86071

June-20-12 12:54:01 PM

86071

Page 1

Item ID: D3531-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 20/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/20 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3531	Rev A								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

4 0 Jm 12-6-23

FLOW CNC Waterjet

1-Cut as per Dwg D3531 Dwg Rev: A Prog Rev: 1A 2-
Deburr if necessary

10001, 0140

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

9 0 Jm 12-6-23

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

4 12 06 24

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Bend as per Dwg D3531								
140		0.00							
140	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
150	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									

4

8/12/06/25

4

12/06/25

4

12/6/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

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Item Name: Bracket

Stop *NS2*

Start Date: 20/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

12/6/27 *(4)*

170

Identify as per dwg & Stock Location: *GA*

0.00

170

Packaging

Memo

0.00

Packaging

SP *12-06-27*

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/6/28 *(J)*

mf
12-06-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-20-12 12:54:05 PM

Page 1

Work Order ID: 86071

86071

Parent Item: D3531-1

D3531-1

Parent Item Name: Bracket

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-09-24 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	255.4178	0.3783	1.592842			

M6061T6S 040

6061-T6 .040 Sheet

**

JM 12-6-23

Location

Loc Qty

Loc Code

MAT021

255.4178

121030

12.9178

121099

242.5

121099

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	86071
Description: Bracket		Part Number:	D3531-1
Inspection Dwg: D3531	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.196	+0.005/-0.001	0.196"	✓		✓	mm03
Ø0.129	+0.005/-0.001	0.131"	✓		✓	
0.33	+/-0.030	0.336"	✓		✓	
2.840	+/-0.010	2.843"	✓		✓	
1.70	+/-0.030	1.699"	✓		✓	
1.45	+/-0.030	1.453"	✓		✓	
0.38	+/-0.030	0.378"	✓		✓	
0.19	+/-0.030	0.190"	✓		✓	
5.88	+/-0.030	5.878"	✓		✓	
12.66	+/-0.030	12.66"	✓		MT	H301
0.600	+/-0.010	0.600"	✓		✓	
1.77	+/-0.030	1.778"	✓		✓	
1.24	+/-0.030	1.24"	✓		✓	
Bend - 1.16	+/-0.030					

Measured by:	Jm	Audited by:	[Signature]	Prototype Approval:	N/A
Date:	12-6-23	Date:	12-06-24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.15	New Issue	KJ/EC/DD	[Signature]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

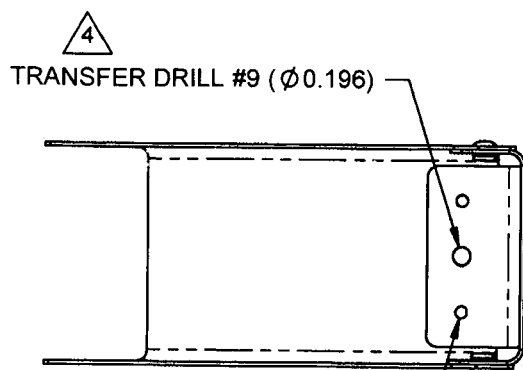
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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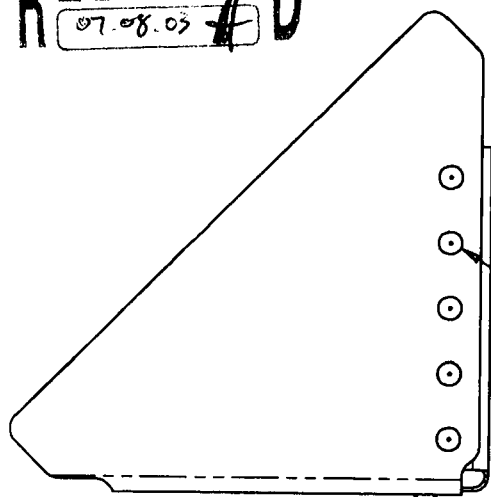


DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED HA	DRAWING NO. D3531	REV. A
DATE 07.06.19		TITLE BRACKET ASSEMBLY	SHEET 1 OF 3
REV A	DATE 07.06.19	DESCRIPTION NEW ISSUE	
		SCALE 1:2	



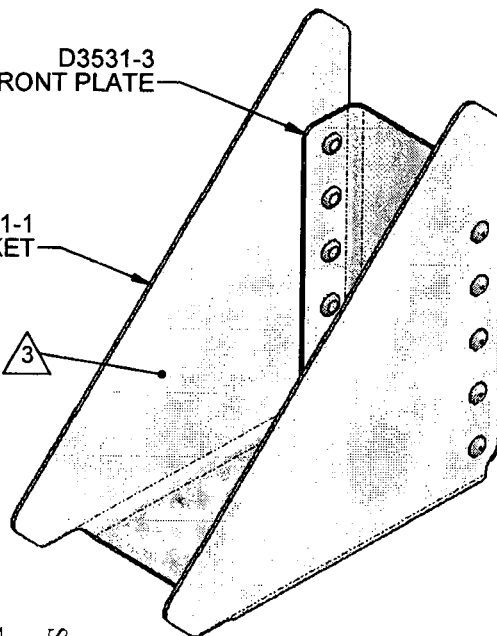
TRANSFER DRILL #30 (Ø0.129)
INSTALL MS20470AD4-4 RIVET
(2 PLACES)

RELEASED
07.08.03

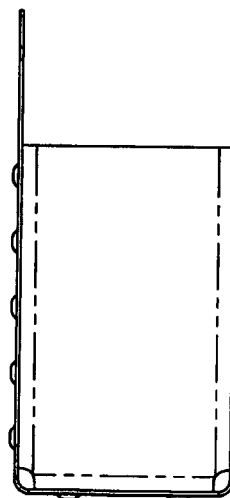


D3531-3
BRACKET FRONT PLATE

D3531-1
BRACKET



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86031 M-5
12/06/20



D3531-041 BRACKET ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY BLACK
SANDTEX (4.3.5.7) PER DART QSI 005 4.3
ALL PARTS
- 2) ASSEMBLE PER DART QSI 003
- 3) IDENTIFY WITH DART P/N "D3531-041" USING
WHITE MARKER ON INSIDE OF BRACKET
ASSEMBLY, WHERE INDICATED
- 4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET
THROUGH D3531-3 BRACKET FRONT PLATE
BEFORE FINISHING

PARTS LIST

QTY.	P/N	DESCRIPTION
X	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVET

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

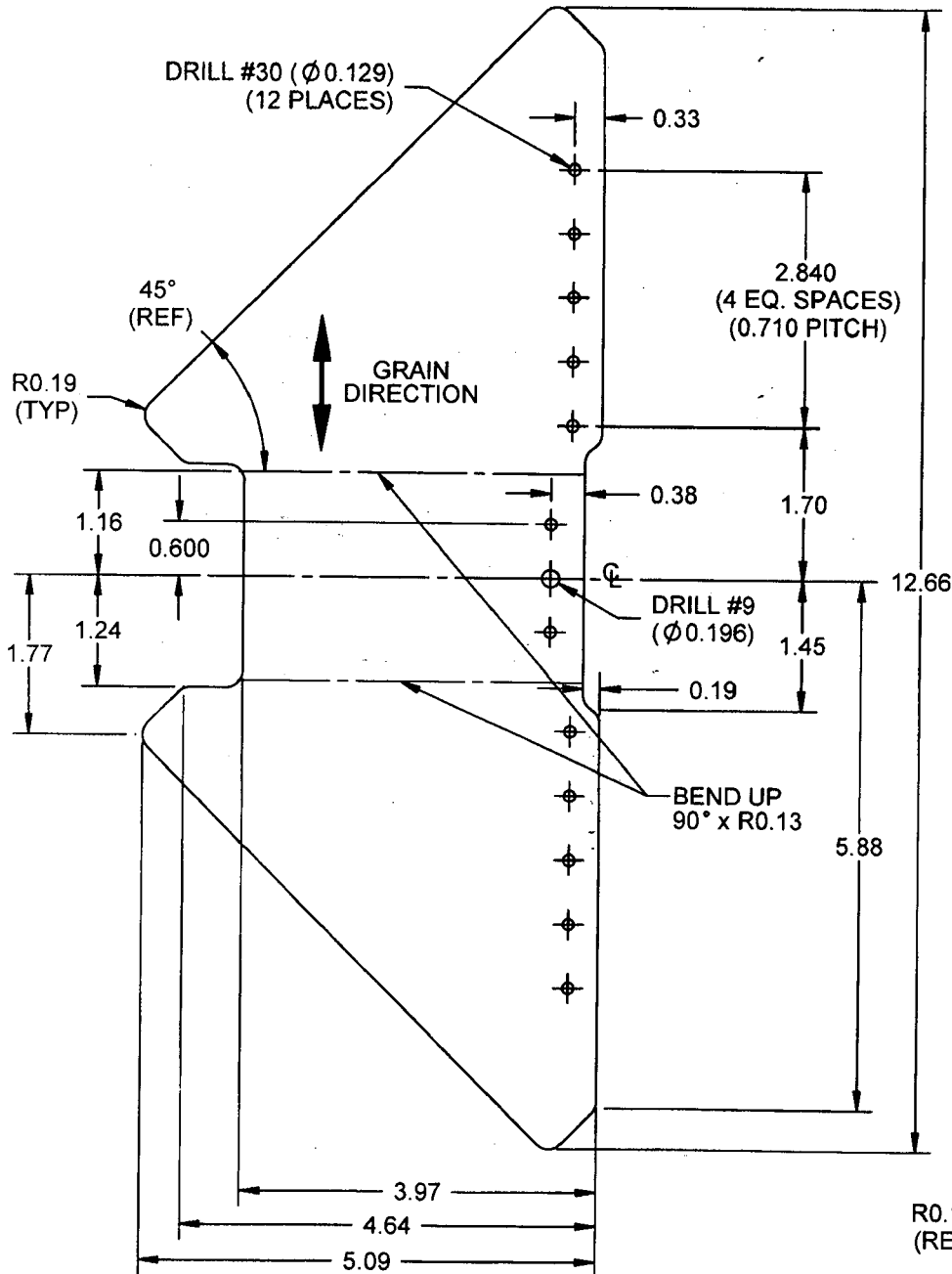
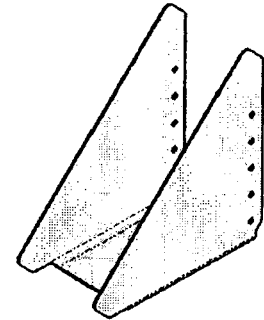
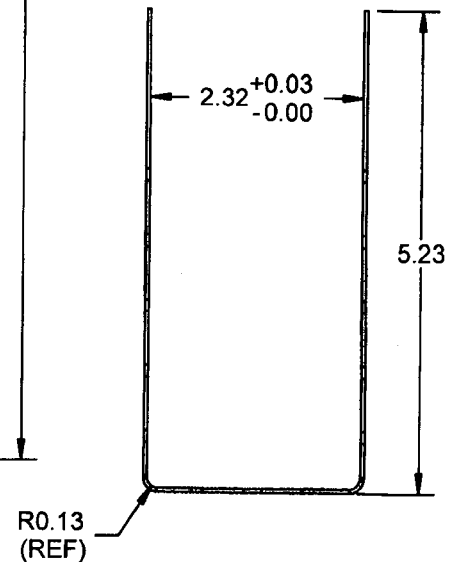
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC (Section A)	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3531	REV. A SHEET 2 OF 3
DATE 07.06.19	TITLE BRACKET ASSEMBLY		SCALE 1:2

**D3531-1F FLAT PATTERN****RELEASED**
07.08.03**D3531-1 BRACKET****NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

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Dart Aerospace Ltd

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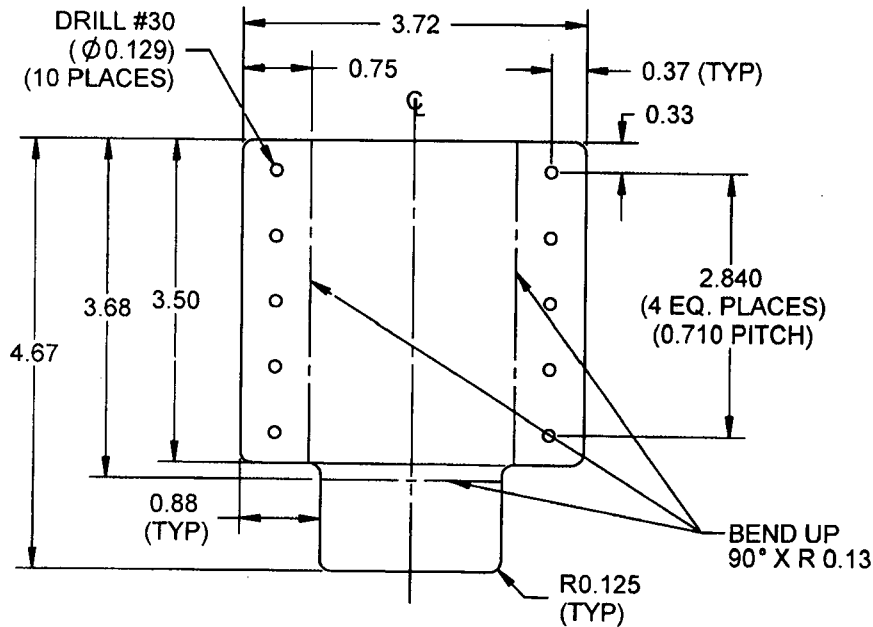
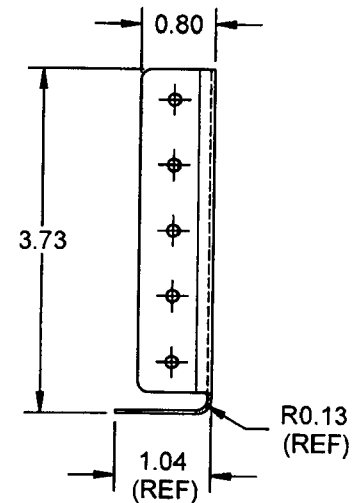
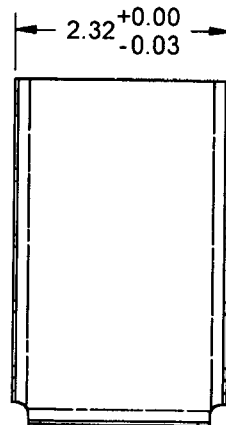
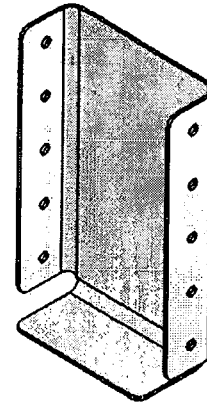
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED #	DRAWING NO. D3531	REV. A SHEET 3 OF 3
DATE 07.06.19		TITLE BRACKET ASSEMBLY	SCALE 1:2

**D3531-3F FLAT PATTERN****RELEASED**
07.08.03 **#****D3531-3 BRACKET FRONT PLATE****NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

86071

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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